

Date: Thursday, 27/11/2008 2:26:12 PM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : TOP PANEL ASS'Y
Job Number : 43823	
Estimate Number : 13034	
P.O. Number :	Part Number : D36509
This Issue : 27/11/2008 S.O. No. :	Drawing Number : D3650 REV.C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : C
Previous Run : 42113	Material :
Written By :	Due Date : 20/12/2008 Qty: 10 Um: Each
Checked & Approved By : <u>JUD 08.11.27</u>	
Comment : Est Rev:A New Issue 07-09-27 DD verified by: EC Est Rev:B ECN 1113P 08-01-22 DD verified by: EC Est Rev:C ecn1162 08-04-02 DD verified by: EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S26GA	304/316 0.018 SHEET
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Comment: Qty.: 0.0536 sf(s)/Unit Total : 0.5355 sf(s)
 304/316 SS sheet 26 ga (0.018" thick)
 Batch: 109398 IB 8-12-15

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3650

Dwg Rev: C
 Prog Rev: C

IB 8-12-15

(B)

2-Deburr if necessary

IB 8-12-15

CP 08/12/16 (B)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SC 08/12/16 (B)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE
 Form as per Dwg D3650

IB 08/12/17

(B)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TOP PANEL ASS'Y

Job Number: 43823

Part Number: D36509

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/12/17 (x13)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and stock

Location: ST115

28 08/12/17 (x13)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/12/18

Job Completion



WMC 08-12-27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8

7

2

1

D

D

0.018
REF1.1
REF**D3650-11 FI**
(MAKE FROM D3650)

C

C

R0.06 0.018
REF0.32
REF

(M) 8.19

D3650-7-8.19 SEAL

1.07

EF. BELL P/N 120-104-1)
COPTERS OR BELL

0.28

S OTHERWISE NOTED
TED
AXIN INCHES
0-7-12.50

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 1000

B

B

RELEASED
08/11/17**D3650-9 & D3650-11 NOTES:**

- 1) MATERIAL: AISI 304/316 STAINLESS ST
PER MIL-S-5059 OR AMS 55
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI.018 UNL
- 4) UNITS: INCHES UNLESS OTHERWISE
- 5) BREAK SHARP EDGES: 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) D3650-9 WEIGHT: 0.05 lb
D3650-11 WEIGHT: 0.007 lb

A

A

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.

REV. C

D3650

SHEET 9 OF 9

TITLE

SCALE

TOP PANEL ASSEMBLY

NTS

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